

Work Order ID 69182

Wednesday, May 04, 2011 10:16:33 AM

Page 1

Item ID: D4366-041

Accept

Revision ID: PRELIM

Item Name: Fwd Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: AADate: 11.05.04

Tooling:

Date:

QC:



Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4366	PA2								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4366-1) Dwg Rev: <u>PA2</u> Prog Rev: <u>PA2</u>								
	2-Deburr if necessary								
110		0.00							
									
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							

**PRELIMINARY ISSUE**

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Start Date: 5/4/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	- inspected by PA2 Dry only 8/16/05 (tu)			*			
130  Brake NC Brake NC	Form as per dwg Memo *** Jigs DT8261 and DT8326.***	0.00 0.00	SB 11/05/05			(1)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Sub 6609			(tu)			

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Item ID: D4366-041

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Fwd Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Large Fab

Memo

0.00

1- on D4367-1, fill cut outs with hardcoat welding rod as per dwg D4366

DT9756

2059 B Hardcoat Welding Rod

BATCH#: M117659

2-weld D4367-1 to wearplate by positioning holes together as per dwg D4366

304 S.S. Welding Rod

BATCH #: M167051

3-Transfer drill holes in bar

X1 ~~6-8-11~~ 11-6-8 12 / JBL

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

P611-06-09

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Required Date: 5/6/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PAR

Memo

0.00

*Due only
8 w/6/09*

180



Small Fab

Small Fab

Memo

1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4366.

Black Rockguard Plus 1 w/11/6/210

0.00

0.00

11 06 09 ①

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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Start Date: 5/4/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED _____ DATE 11/05/04

RD2382 ME 11-06-23

Picklist Print

Page 1

Wednesday, May 04, 2011 10:16:29 AM

Work Order ID: 69182



Parent Item: D4366-041



Parent Item Name: Fwd Wearplate Assembly

Start Date: 5/4/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4367-1

Manufactured

No

150

Each

1.0000

1

1



11-6-8

Bar

Location

Loc Qty

Loc Code

FG

1

68401

1

M304S18GA

Purchased

No

100

sf

129.0000

2.13

2.242105



11-5-4

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

129

112178

4

113062

18

116135

26

116604

12

116979

69

116604

①

DART AEROSPACE LTD		Work Order: 69182
Description: FWD WEARPLATE ASSEMBLY		Part Number: D4366-041
Inspection Dwg: D4366-0 Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

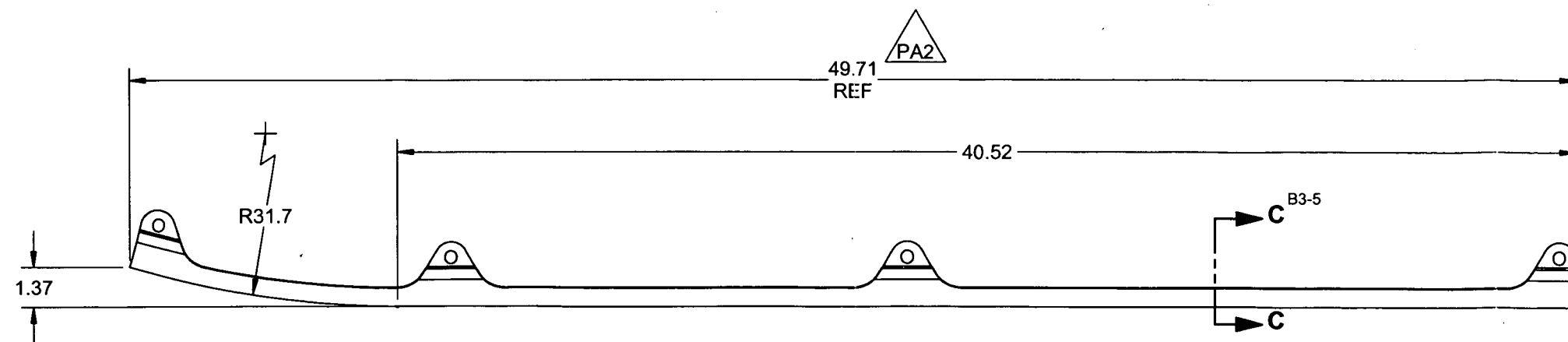
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	±.005 - .001	.191	✓		V HB02	
.400	±.010	.400	✓		V	
.050	±.010	.050	✓		V	
.875	±.010	.875	✓		V	
.125	±.010	.127	✓		V	
.156	±.030	.156	✓		V	
.80	±.030	.797	✓		V	
4.50	±.030	4.500	✓		V	
7.00	±.030	7.004	✓		V	
5.320	±.010	5.320	✓		V	
28.000	±.010	28.000	✓		T HB01	
3.00	±.030	3.004	✓		V	
4.00	±.030	3.998	✓		V	
22.335	±.010	22.335			T	
37.960	±.010	37.960			T	
48.460	±.010	48.460			T	
49.63	±.030	49.625	✓		T	
.050	±.010	.048	✓		V	

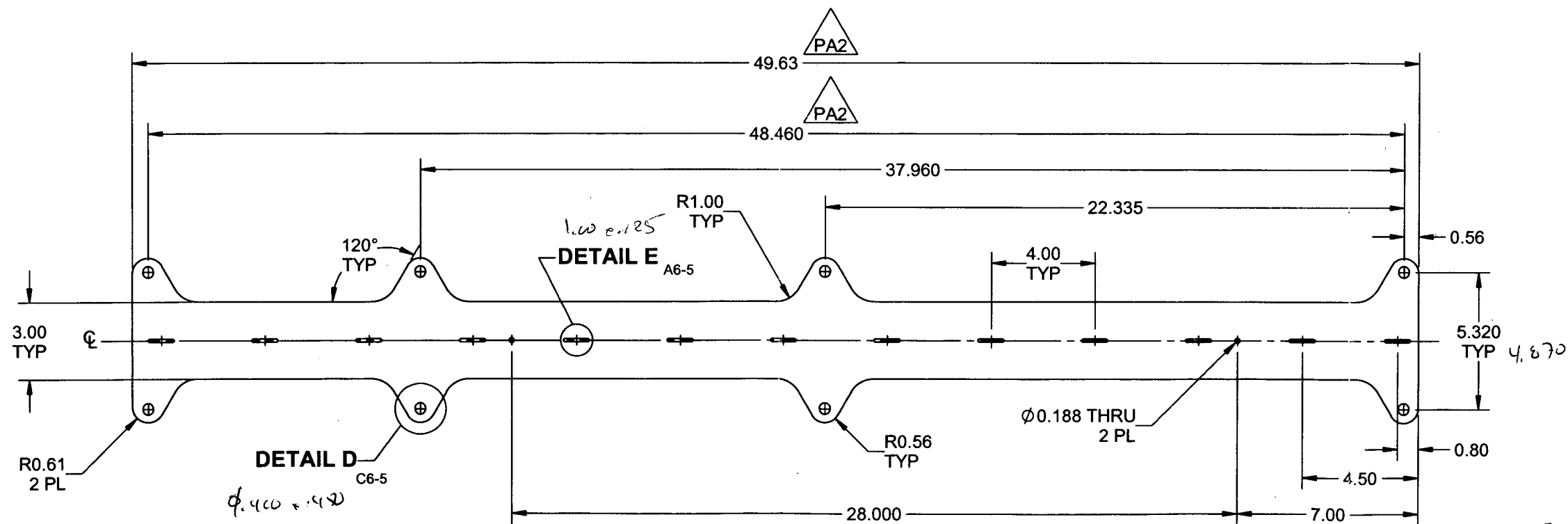
Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-5-4	Date: 11/6/05	Date:

to P92 Drawn by

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4366-1 PLATE
(MAKE FROM D4366-1F)



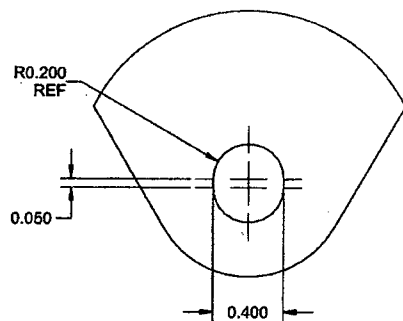
D4366-1F PLATE

**PRELIMINARY
ISSUE**

NOTES:

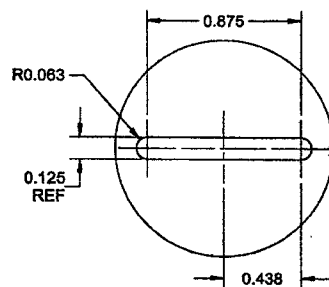
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.39 lbs

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4366	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.</small>	



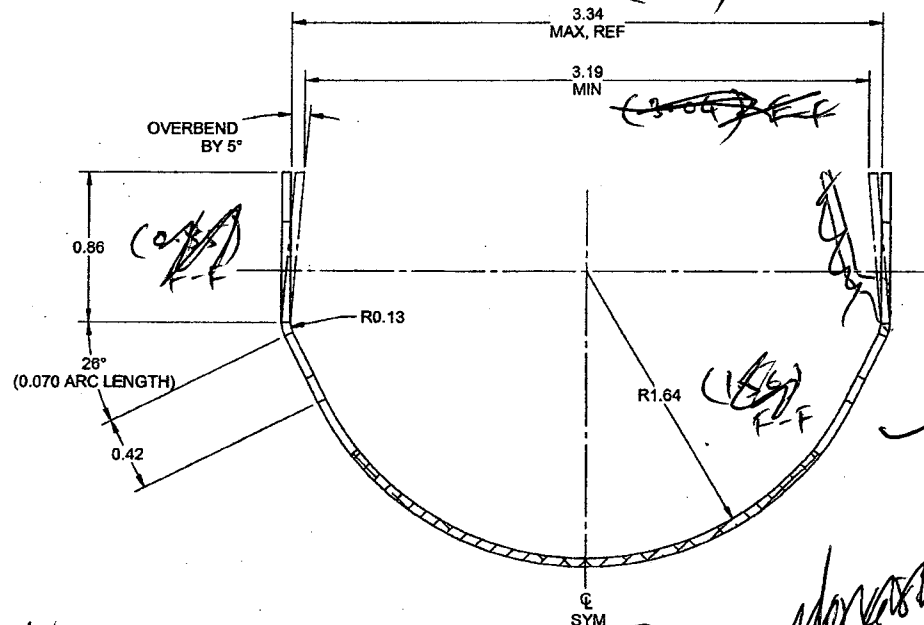
DETAIL D
SLOT DETAIL TYP

B6-3
B5-4



DETAIL E
SLOT DETAIL TYP

B5-3
B3-4



SECTION C-C

D3-3
D3-4

**PRELIMINARY
ISSUE**

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4366	REV. PA1
MFG. APPR.	<i>[Signature]</i>		SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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